

# Work Order ID 78436

**\*78436\***

Page 1

January-09-12 1:58:08 PM

Item ID: D2221 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 350 Basket Base  
 Start Date: 09/01/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 16/01/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/09 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2221	Rev H

100 Large Fab 0.00

**\*100\***

Large Fab

Large Fab

Memo

0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221  
 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221  
 3- tack weld mesh on basket as per dwg D2221  
 A/R ER316 S.S. Rod Batch: 4115778

\*\*\*PLEASE NOTE\*\*\*

IF MAKING -041A OR -043A :  
 DRILL HOLES FOR GAS SPRING  
 IN D3825-041 AS PER  
 DSI 9473

12.01.16 (1x)

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*110\***

QC

Quality Control

Memo

0.00

12.01.17 1x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 2

January-09-12 1:58:09 PM

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
<b>*125*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

*1X 10 M-L 12/04/17*

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
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**\*130\***

Powdercoat

Powder Coating

## Memo

1- Plug holes prior to

1ST COAT:

START TIME: 3:30

OVEN TEMPERATURE: 400 OF

FINISH TIME: 4:55

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

*IXP M / 12/01/17*

140	QC3- Inspect Part Finish	0.00							
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**\*140\***

QC

Quality Control

## Memo

*1 BR 12-1-18*

*M 119480*

W/O:		WORK ORDER CHANGES					
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Page 4

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location	0.00	78418			1		BL 12-1-18	
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/11/18 *[Signature]*  
 12-01-18  
 ①

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# Picklist Print

January-09-12 1:58:13 PM

Page 1

Work Order ID: 78436

\*78436\*

Parent Item: D2221

\*D2221\*

Parent Item Name: 350 Basket Base

Start Date: 09/01/2012

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM  
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N  
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 *D2221-1* Rib		Manufactured	No			100	Each	4.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA006			4						
				72297			4						
D2221-5 *D2221-5* Rib		Manufactured	No			100	Each	6.0000	2	2			
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA006			6						
				67117			2						
				71218			4						
D2221-7 *D2221-7* Rib		Manufactured	No			100	Each	5.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA006			5						
				71219			1						
				73203			4						

\*\*

12.01.16

\*\*

12.01.16

\*\*

12.01.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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January-09-12 1:58:13 PM

Page 2

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Parent Item: D2221

**\*D2221\***

Parent Item Name: 350 Basket Base

Start Date: 09/01/2012

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No

100 Each 8.0000 2 2

**\*D2232-3\***

Basket Hinge

\*\*

*Handwritten:* 12.01.16

Location

Loc Qty

Loc Code

WA005

8

75581

8

D2235-1 Manufactured No

100 Each 10.0000 2 2

**\*D2235-1\***

Basket Rib

\*\*

*Handwritten:* 2x  
12.01.16

Location

Loc Qty

Loc Code

WA

6

77230

6

WA005

4

66895

4

D2581 Manufactured No

100 Each 81.0000 2 2

**\*D2581\***

Mounting Bracket

\*\*

*Handwritten:* 12.01.16

Location

Loc Qty

Loc Code

WA005

81

69739

1

70766

2

75280

1

77045

48

77523

29

D3442-1 Manufactured No

100 Each 13.0000 2 2

**\*D3442-1\***

Shim

\*\*

*Handwritten:* 12.01.16

Location

Loc Qty

Loc Code

WA005

13

71783

13

*Handwritten:* 2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 78436

**\*78436\***

Parent Item: D2221

**\*D2221\***

Parent Item Name: 350 Basket Base

Start Date: 09/01/2012

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3825-041

Manufactured No

100 Each

6.0000

2

2

\*\*

*LS* 12.01.16

**\*D3825-041\***

Rib Assembly (Basket End)

Location

Loc Qty

Loc Code

WA006

6

77529

6

2x

D3826-041

Manufactured No

100 Each

4.0000

2

2

\*\*

*LS* 12.01.16

**\*D3826-041\***

Rib / Gusset Assembly

Location

Loc Qty

Loc Code

WA

4

77464

4

2x

D3827-041

Manufactured No

100 Each

3.0000

1

1

\*\*

*LS* 12.01.16

**\*D3827-041\***

Rib Assembly (Inboard)

Location

Loc Qty

Loc Code

WA006

3

72729

3

1x

D3832-1

Manufactured No

100 Each

2.0000

1

1

\*\*

*LS* 12.01.16

**\*D3832-1\***

Mesh (Base)

Location

Loc Qty

Loc Code

WA

2

73748

2

1x

D3833-1

Manufactured No

100 Each

2.0000

2

2

\*\*

*LS* 12.01.16

**\*D3833-1\***

Mesh (Base End Face)

Location

Loc Qty

Loc Code

WA035

2

70470

2

2x

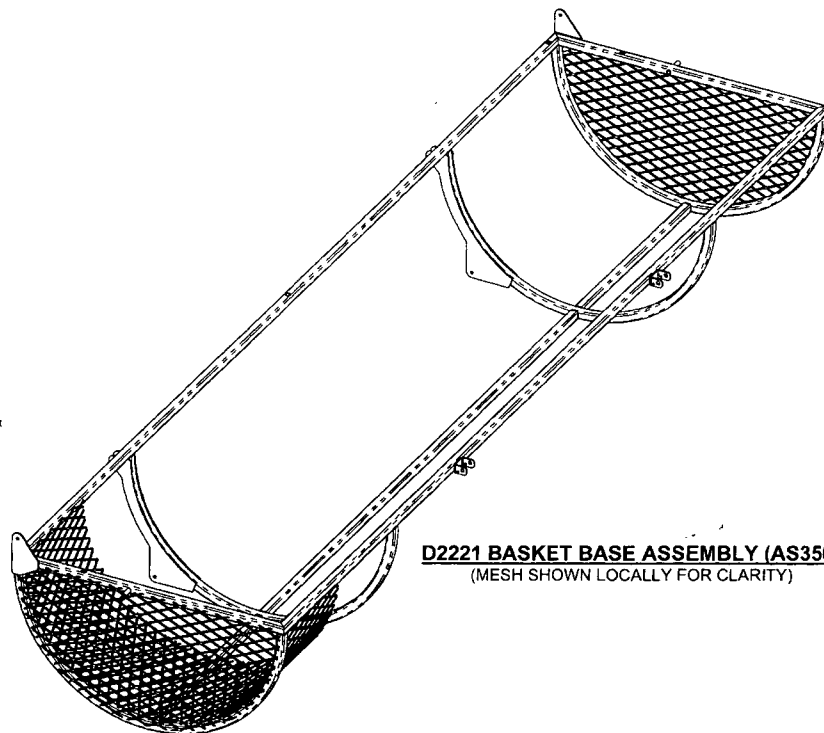
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**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO CHANGE  
WITHOUT NOTICE  
WORK ORDER

NO. 78436 M.L.J  
12/01/09

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	AS	D2221	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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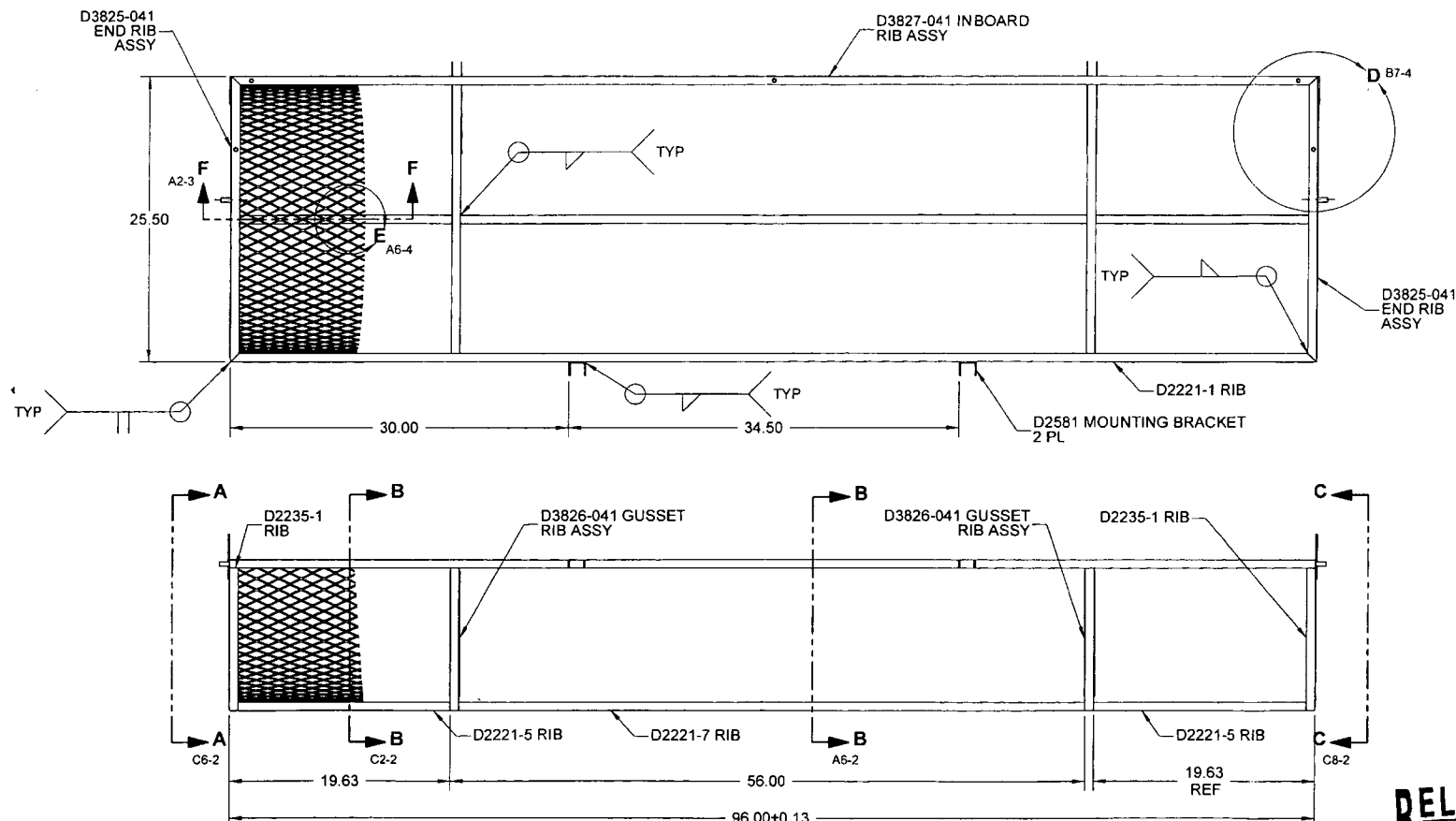
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**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
06/11/18

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET BASE ASSEMBLY (350)</b> NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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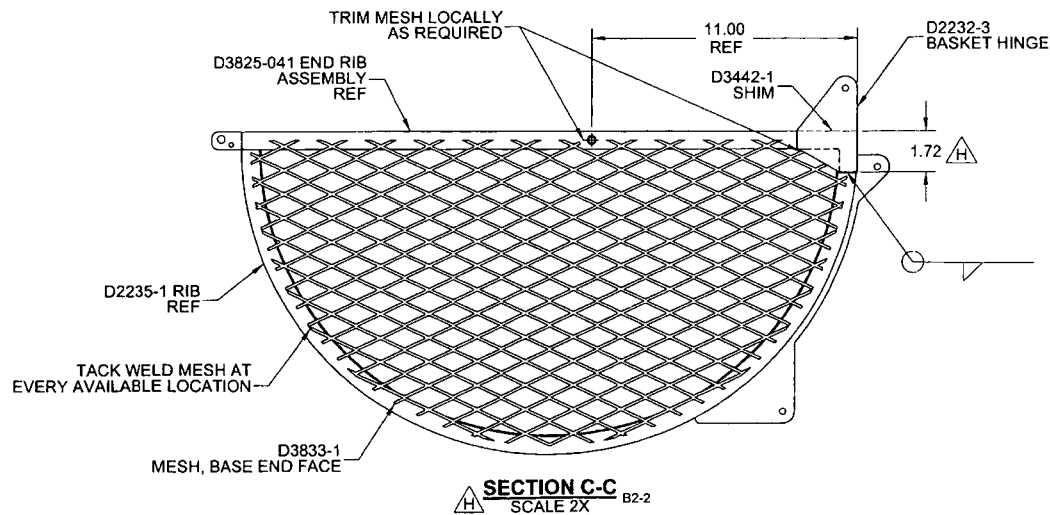
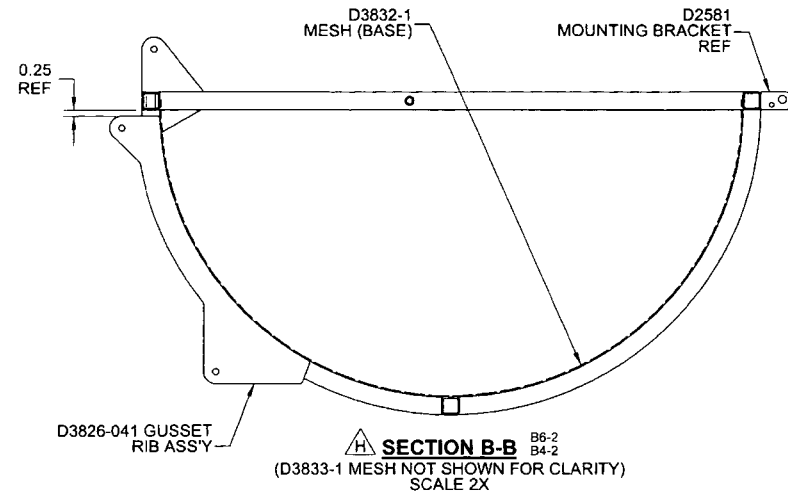
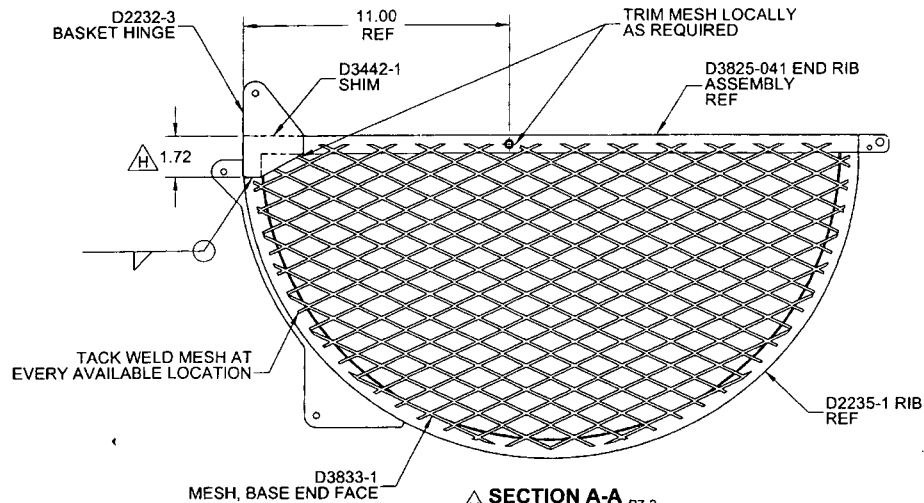
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70436



RELEASED  
03/11/18

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	433	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 3 OF 5
APPROVED	11	TITLE	SCALE
DE APPR.		<b>BASKET BASE ASSEMBLY (350) NTS</b>	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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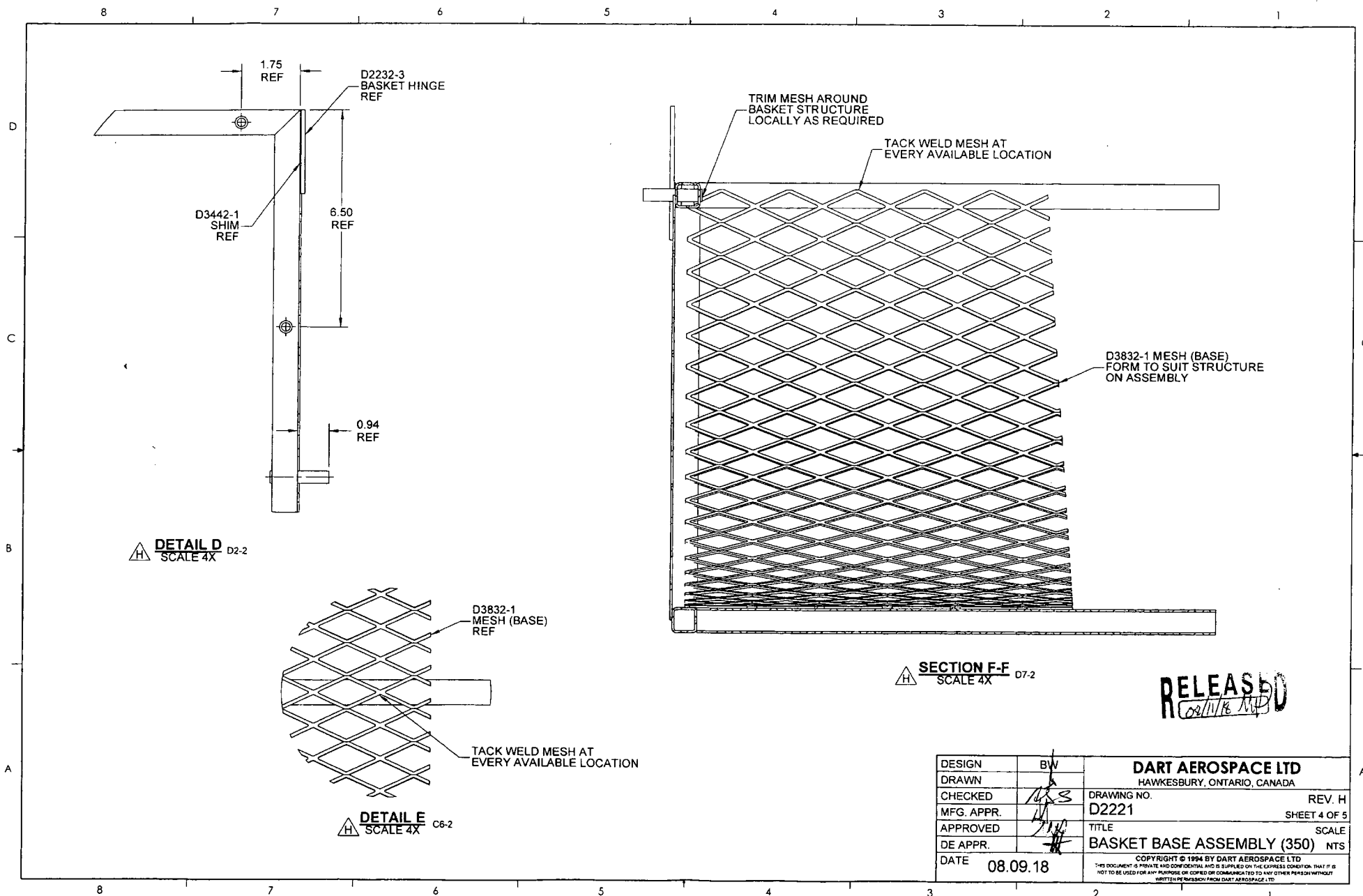
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350) NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

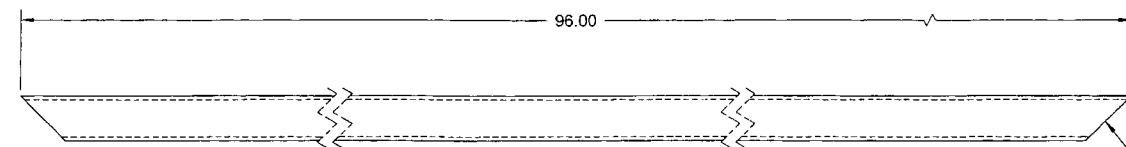
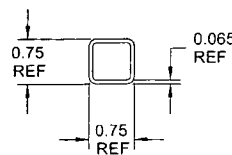
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

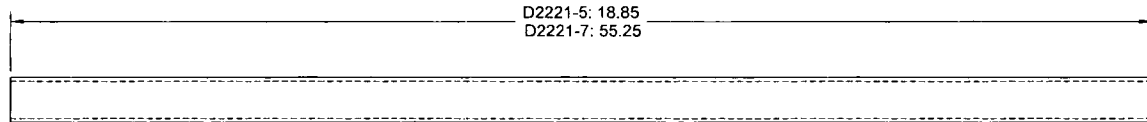
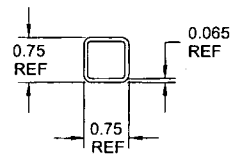
**NOTE:** Date & initial all entries

78436



0.75 X 45° CHAMFER  
2 PL

**D2221-1 RIB**



D2221-5: 18.85  
D2221-7: 55.25

**D2221-5/-7 RIB**

**RELEASED**  
06/10/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries